

Work Order ID 52312

Tuesday, September 22, 2009 2:51:23 PM



Page 1

Item ID: D3065-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

PL mjd

Date:

09-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3065 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr as required

B 9-11-3

(52)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-11-3

(Pb) >

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control


> 507/10/09

(x57)

Back at 4
For
Tung

W/O: 52312

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/16/03 9/16/03	A 120	Took Qty x1 Part for QC Template/inspection	E	9/16/03	x1		 02/16/03

Part No: D3065-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3065								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

u/s

9/30/09/11/06 (51)

S 09/11/06

Cantos
(ST)

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Item ID: D3065-1

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Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

M-L 09/11/09

(51x)

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

M-L 09/11/09

(Sk)

Quality Control

180

Identify as per dwg & Stock Location: C-A

0.00



Packaging

Memo

0.00

Packaging

09/11/09 (51x)

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Page 4

Item ID: D3065-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/09 *[Signature]*BS/09-11-9
(51)

Picklist Print

Tuesday, September 22, 2009 2:51:22 PM

Page 1

Work Order ID: 52312



Parent Item: D3065-1RevB



Parent Item Name: Step Spacer

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	220.2565	5.2126	6.7763		
2024-T3 .040 sheet												

B 9-11-3

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

220.2564789

110337

6.4

111786

39.0665789

112291

91.9258

112331

82.8641

112291

52

DART AEROSPACE LTD		Work Order:	52312
Description: Step Spacer		Part Number:	D3065-1
Inspection Dwg: D3065 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.250	X			
2.093	+/-0.010	2.096	X			
3.936	+/-0.010	3.936	X			
4.186	+/-0.010	4.191	X			
0.587	+/-0.010	.587	X			
Ø0.128	+0.005/-0.001	.132	X			
R0.125	+/-0.010	.125	X			
3.465	+/-0.010	3.466	X			
Ø1.250	+0.012/-0.001	1.251	X			
0.368	+/-0.010	.368	X			
0.871 (Pitch)	+/-0.005	.873	X			
0.040	+/-0.010	.042	X			

Measured by:	IB	Audited by:	S	Prototype Approval:	
Date:	9-11-3	Date:	09/11/03	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	

SHOP COPY



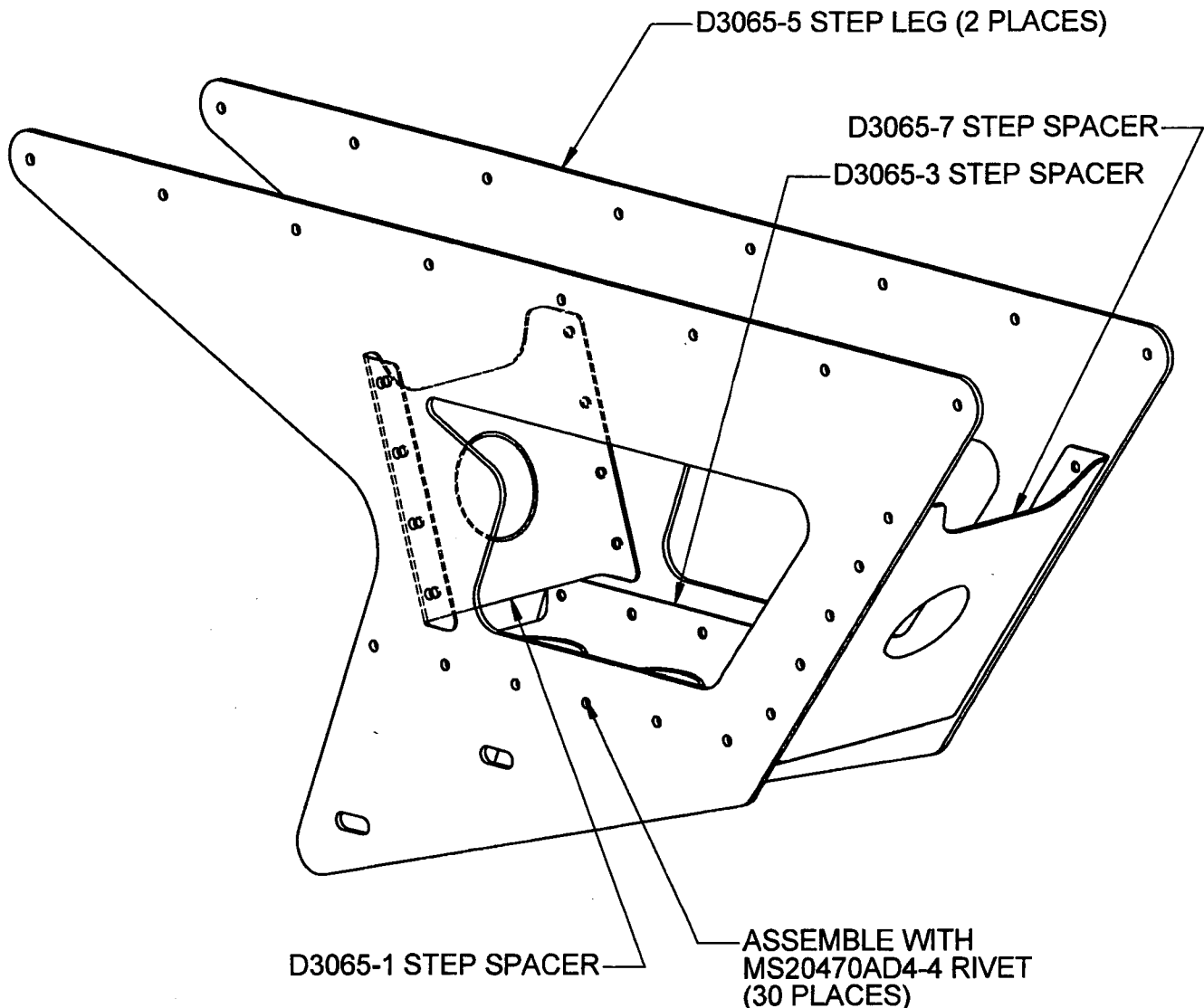
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 32312

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY SCALE 1:2	
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

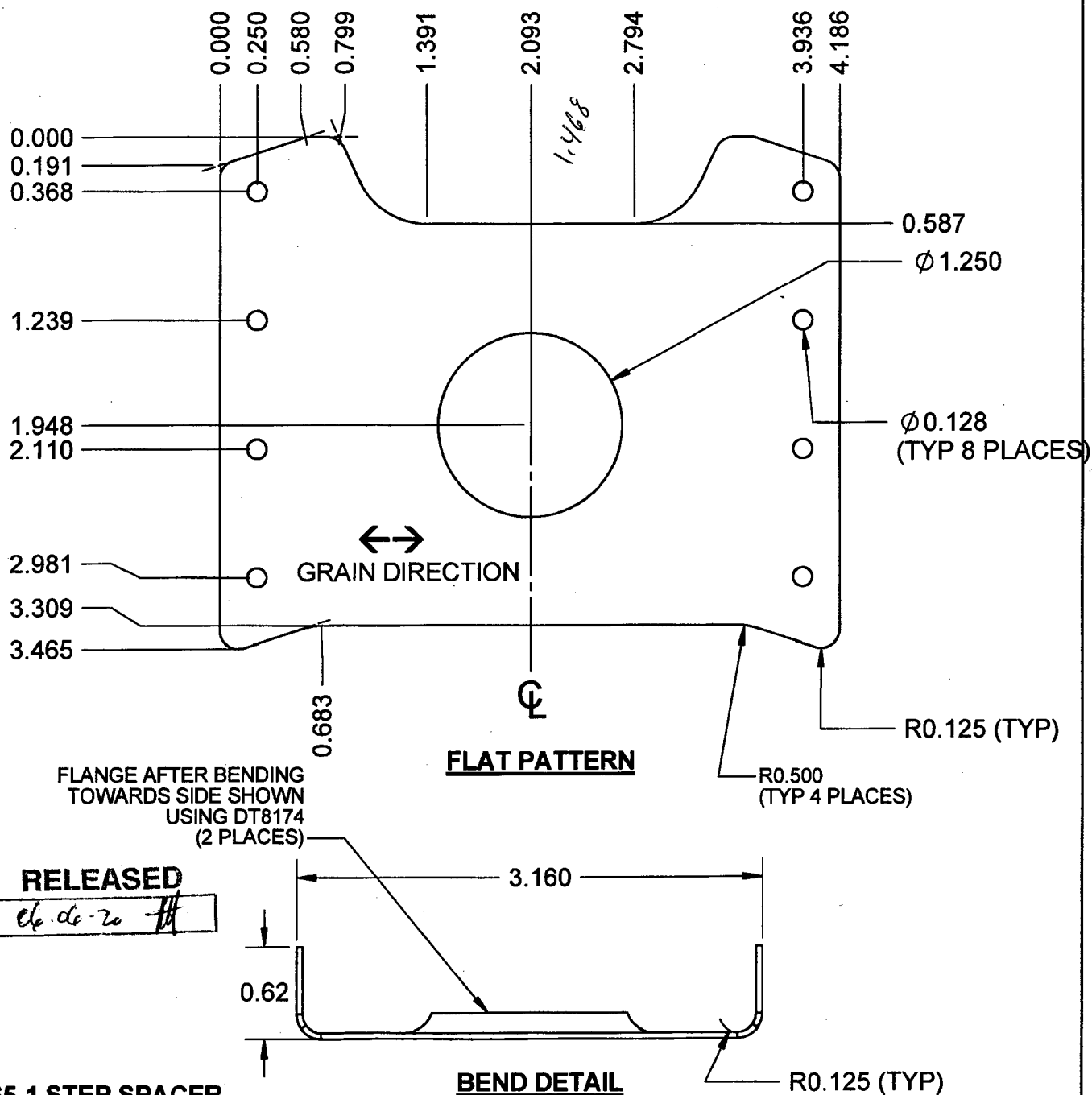
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52312



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

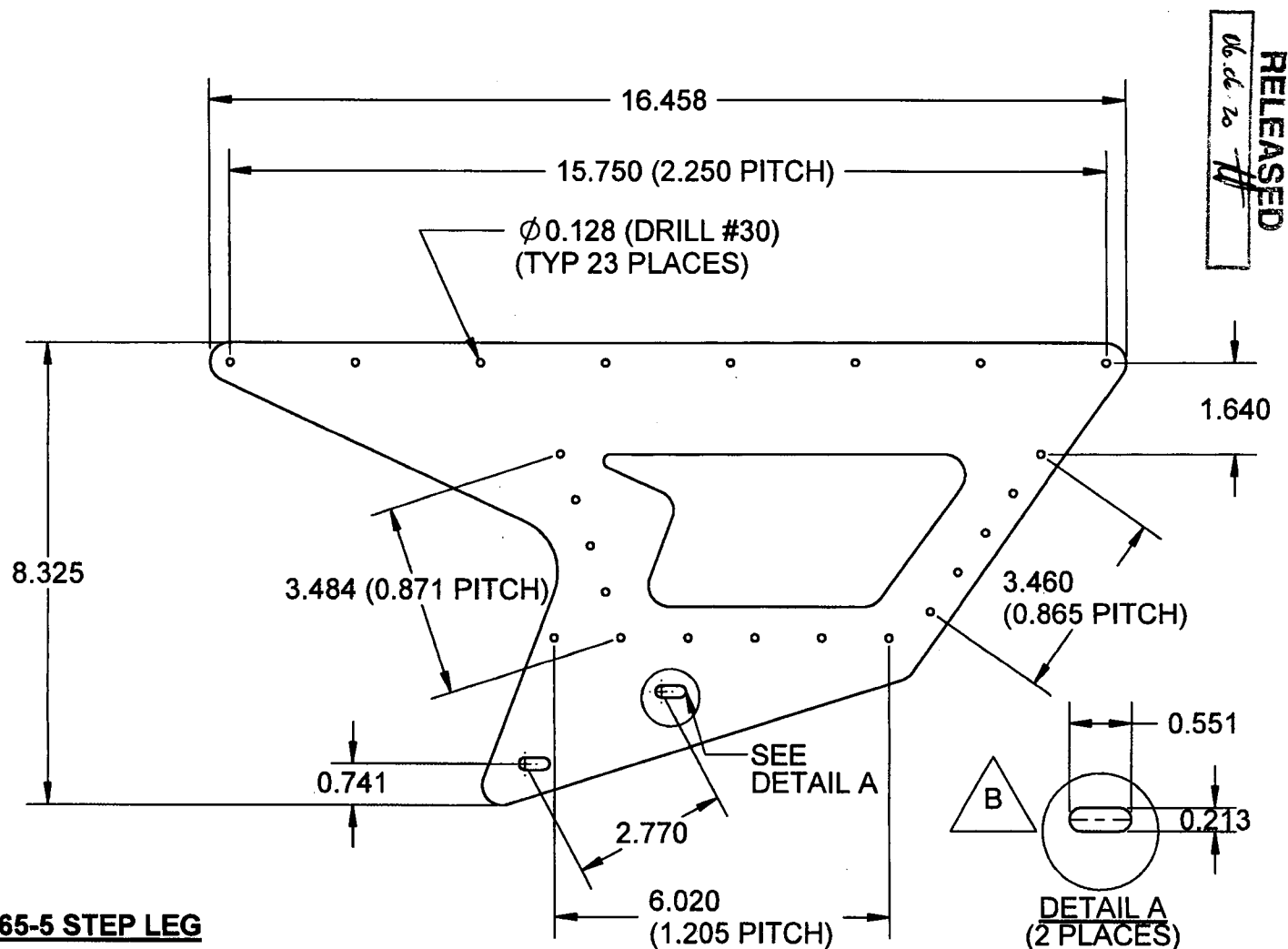
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52312

DART

DESIGN	40	DRAWN BY	C.B.	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3065
DATE	06.05.23			REV. B
				SHEET 4 OF 5
				SCALE 1:3
				TITLE STEP LEG ASSEMBLY

**D3065-5 STEP LEG**

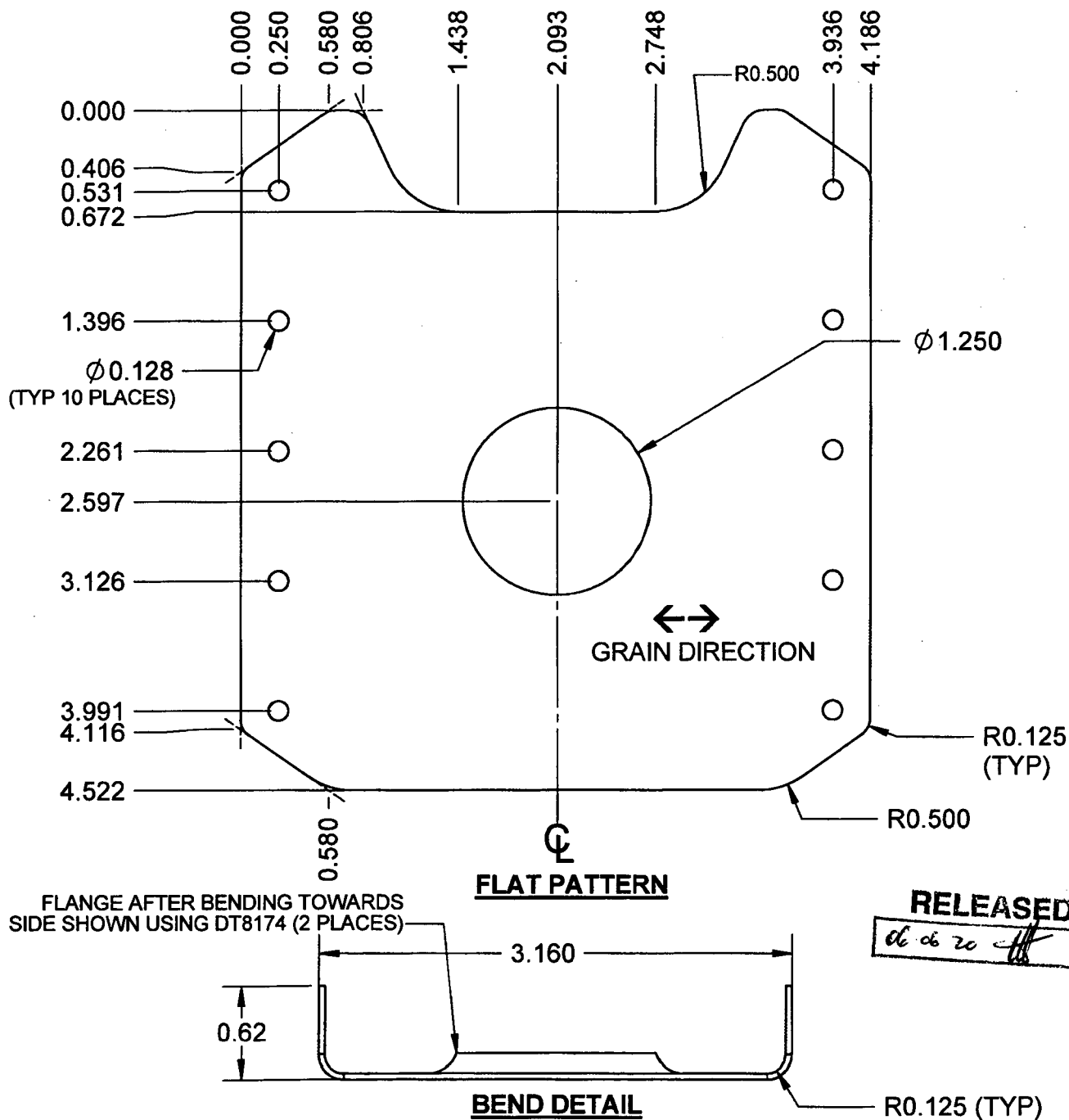
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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